

Date: Tuesday, 21/11/2006 10:08:03 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 29538
 Estimate Number : 10673
 P.O. Number : N/A Part Number : D2975
 This Issue : 21/11/2006 - S.O. No. : N/A Drawing Number : D2975 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A
 Previous Run : 29538 Material : N/A
 Due Date : 15/12/2006 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: C 02.10.23 Re-format KJ
 Est Rev:D Now on Waterjet 06-11-21 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.2896 sf(s)/Unit Total : 5.7918 sf(s)
 1010/1025/A21/6aA SHEET .063"
 Batch: M101463 MM 06 11 30 (20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2975
 Dwg Rev: A MM 06 11 30 (20)
 Prog Rev: A

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE MM 06 11 30 (20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK MM 06 11 30 (20)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form as per dwg D2975 using DT8179

SAD 06:12:02 (20) DT 8241 DT 8324

Date: Tuesday, 21/11/2006 10:08:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29538

Part Number: D2975

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11/06/12/05

(20)

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8210 as per Dwg D2975 & QSI 004

Qty Description Batch

A/R 7560 Hardcoat Rod M10 2885

MF. 06-12-27

(20)

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

07/01/03 (20)

9.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL / a.m 07/01/04 (20)

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

FL 07/01/04 (20)

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SH112

07/01/04 (20)

PU 7/1/04

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07.01.05

Job Completion

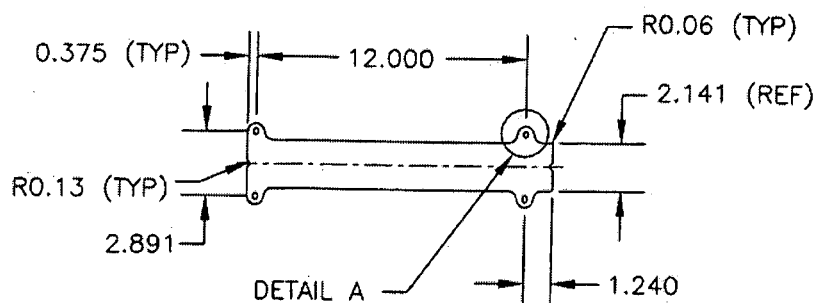


U 07.01.05

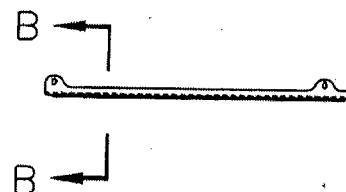


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2975	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE WEARPLATE	SCALE 1:8
A	00.03.10	NEW ISSUE	

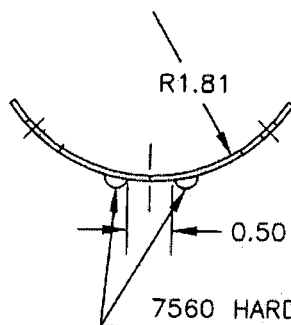
FLAT PATTERN



BENDING DETAIL

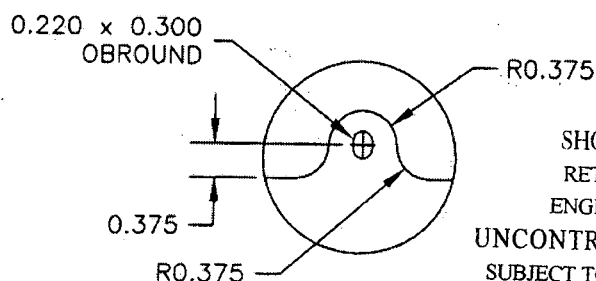


SECTION B-B SCALE 2:5



7560 HARDCOAT WELDS TO
WITHIN 0.25 OF WEARSHOE
ENDS 0.063 TO 0.125 THICK

DETAIL A SCALE 2:5



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29538

RELEASED
00.05.11 *[Signature]*

BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
16 GAUGE (0.063 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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